

Work Order ID 80407

80407

Page 1

February-21-12 9:06:15 AM

Item ID: D3650-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Aft Panel

Stop *NS2*

Start Date: 21/02/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/02/21 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3650	Rev C								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3650 Dwg Rev								
384 .010	Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

SCRAP

SWP

5.21.03.07

12 . 03 . 06 (2)

12 . 03 . 07 (2)

(+2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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2

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D3650	0.00 0.00				2			<i>S</i> 12/09/12
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<i>u</i> 12/09/12
150 *150* Small Fab Small Fab	Small Fab Memo Assemble as per dwg D3650	0.00 0.00							

W/O:		WORK ORDER CHANGES					
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Work Order ID 80407***80407***

Page 3

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Item ID: D3650-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Aft Panel

Stop ***NS2***

Start Date: 21/02/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

11209-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

February-21-12 9:06:19 AM

Page 1

Work Order ID: 80407

80407

Parent Item: D3650-1

D3650-1

Parent Item Name: Aft Panel

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
 IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC
 IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21062-3K

Purchased

No

100

Each

56.0000

3

6

MS21062-3K

**

Nut Plate

Location

Loc Qty

Loc Code

ST302

56

109590

6

117343

50

M304S26GA

Purchased

No

150

sf

94.8000

1.583

3.332632

M304S26GA

**

304/316 0.018 SHEET

Location

Loc Qty

Loc Code

MAT020

94.8

117798

94.8

MS20427M3-3

Purchased

No

150

Each

788.0000

18

36

MS20427M3-3

**

Rivet

Location

Loc Qty

Loc Code

ST318

788

118384

788

m 12:03:06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

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Work Order ID: 80407

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Parent Item: D3650-1

D3650-1

Parent Item Name: Aft Panel

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 2.00

Required Qty: 2.00

MS21060-3K

Purchased

No

150

Each

137.0000

6

12

MS21060-3K

Nut Plate

Location

Loc Qty

Loc Code

ST302

137

116857

17

117423

20

117977

50

118267

50

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order: 80407
Description: Aft Panel		Part Number: D3650-1
Inspection Dwg: D3650	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.098	✓		VWV	HB-02
Ø0.213	+0.005/-0.001	0.213	✓		VWV	"
Ø0.250	+0.005/-0.001	0.250	✓		VWV	"
0.25	+/-0.030	0.253	✓		VWV	"
0.344	+/-0.010	0.347	✓		VWV	"
0.35	+/-0.030	0.350	✓		VWV	"
0.312	+/-0.010	0.316	✓		VWV	"
2.26	+/-0.030	2.281	✓		VWV	"
7.18	+/-0.030	7.19	✓		VWV	"
9.55	+/-0.030	9.555	✓		VWV	Prod-W-J-02
10.66	+/-0.030	10.668	✓		VWV	Prod-W-J-02
12.02	+/-0.030	12.02	✓		M.T	HB-01
16.65	+/-0.030	16.65	✓		M.T	"
17.58	+/-0.030	17.60	✓		M.T	"
16.61	+/-0.030	16.61	✓		M.T	"
0.12	+/-0.030	0.113	✓		VWV	" HB-02
0.17	+/-0.030	0.17	✓		VWV	"
15.80	+/-0.030	15.80	✓		M.T	HB-01
3.950	+/-0.010	3.950	✓		VWV	HB-02
2.02	+/-0.030	2.025	✓		VWV	"
4.03	+/-0.030	4.10	✓		VWV	HB-02
6.13	+/-0.030	6.139	✓		VWV	"
8.23	+/-0.030	8.22	✓		VWV	"
10.31	+/-0.030	10.300	✓		VWV	Prod-W-J-02
12.25	+/-0.030	12.25	✓		M.T	HB-01
0.018	+/-0.010					

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval: N/A
Date: 12.03.07	Date: 12/03/07	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	[Signature]
B	09.06.15	Dimensions updated per Dwg Rev C	KJ	[Signature]

049
125
106

Dart Aerospace Ltd

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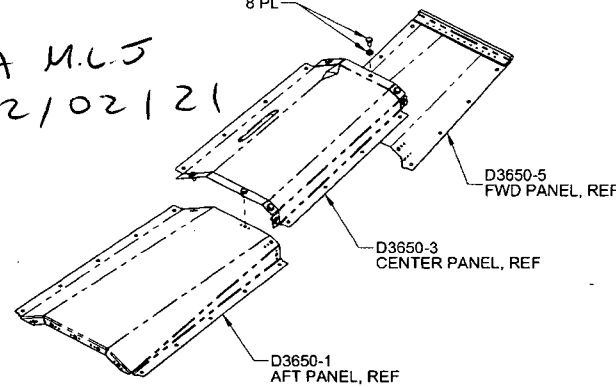
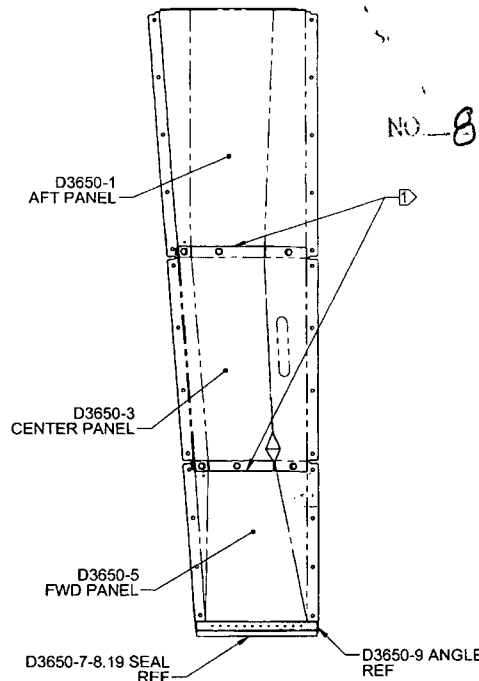
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY -041	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER

AN3C-3A BOLT
AN960C10 WASHER
8 PL

NO 80407 M.L.S
12/02/21



DEO ATTACHED

UNDER REVIEW

OK 07.05.18
PAR 07.05.18

RELEASED
08.11.17

D3650-041 TUNNEL TOP PANEL ASSEMBLY

NOTES:

- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) TORQUE FASTENERS 15 TO 25 in-lb
- 7) WEIGHT: 3.3 lbs

C	REFORMATTED TO NEW STANDARDS; RELOCATED PART LIST (ZN D2-2); ADDED SECTION VIEW J-J & REVISE DIMENSIONS (ZN B7-5, C4-5); ADDED RECESS LOCATION & REVISED DIMENSIONS (ZN C6-6, D5-6); MS20615-4M5 WAS CR3523-4-03 & NAS1149CN432R WAS AN960C4 (ZN D5-7; B5-7; B8-7)	RF	08.10.14
B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11/-11F TO SHEET 9; ADDED DETAIL 1 SHEET 9: RELOCATED D3650-11/-11F FROM SHEET 6; UPDATED DIMS O: D3650-11/-11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3650	SHEET 1 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TOP PANEL ASSEMBLY	1:8
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

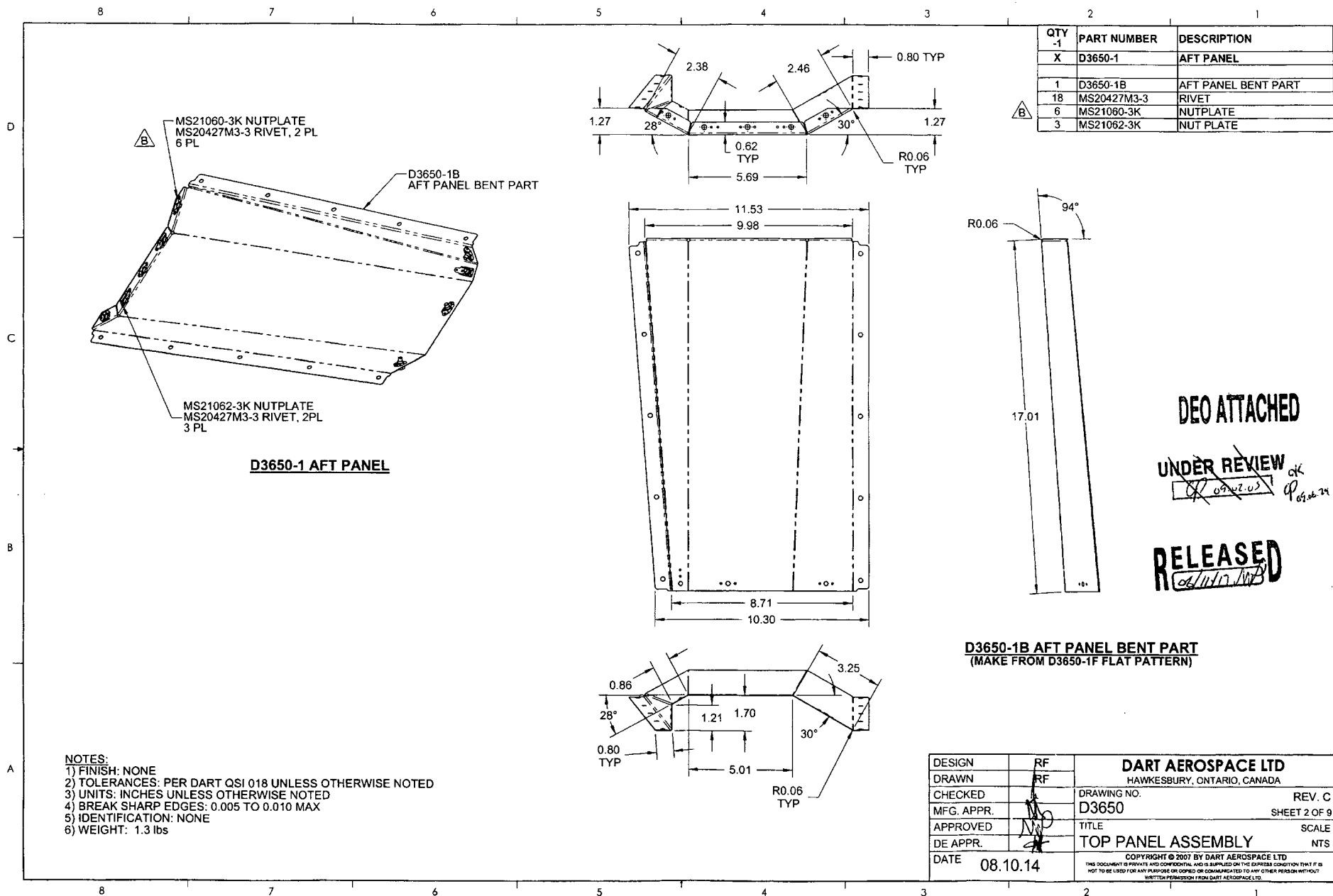
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

80407



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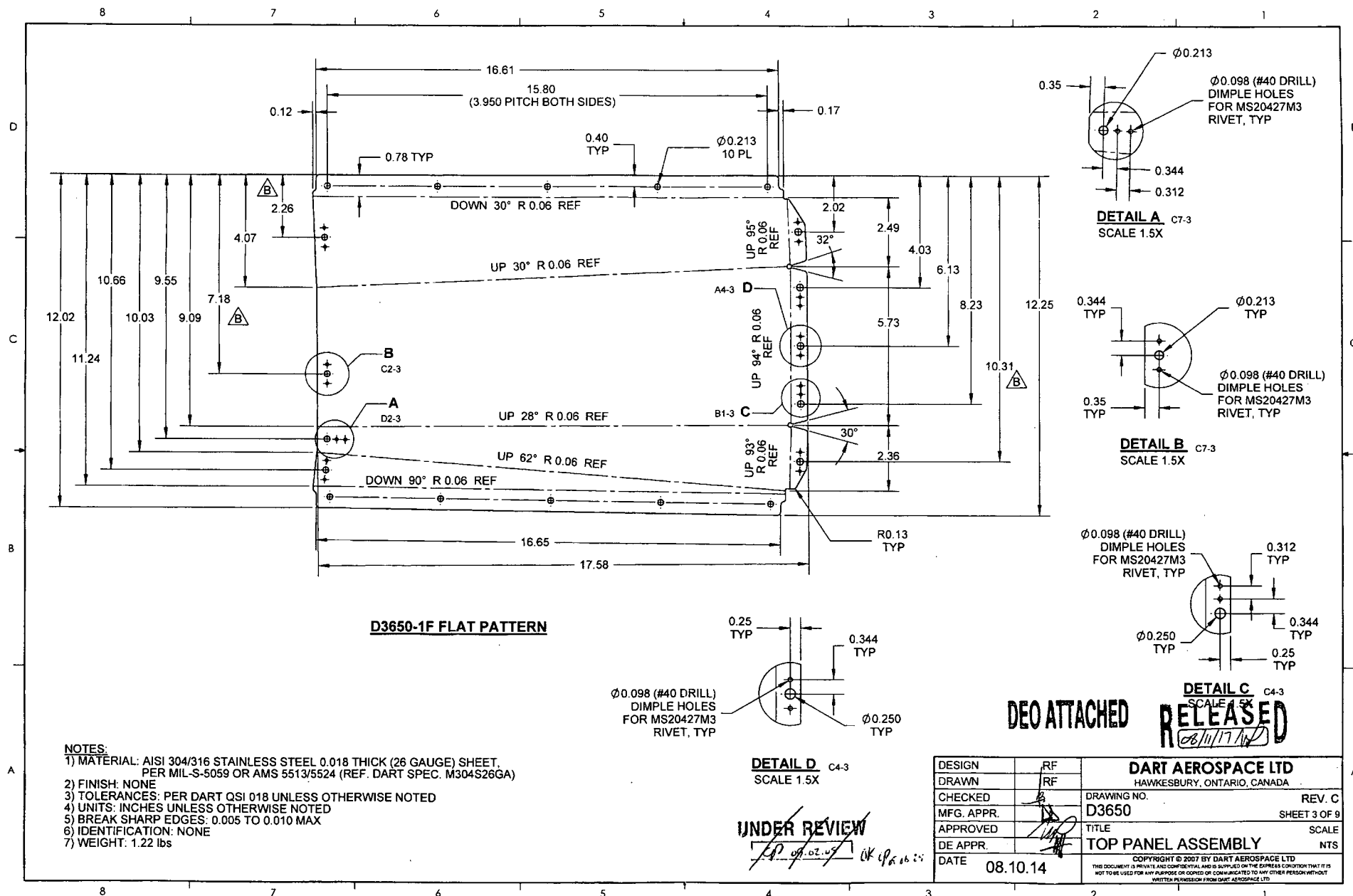
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80407



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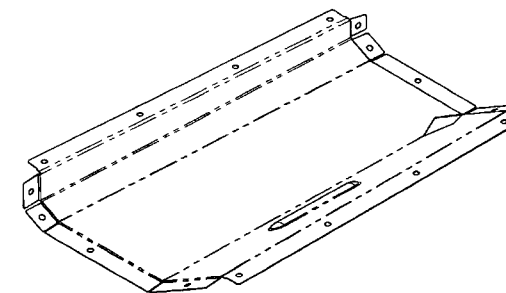
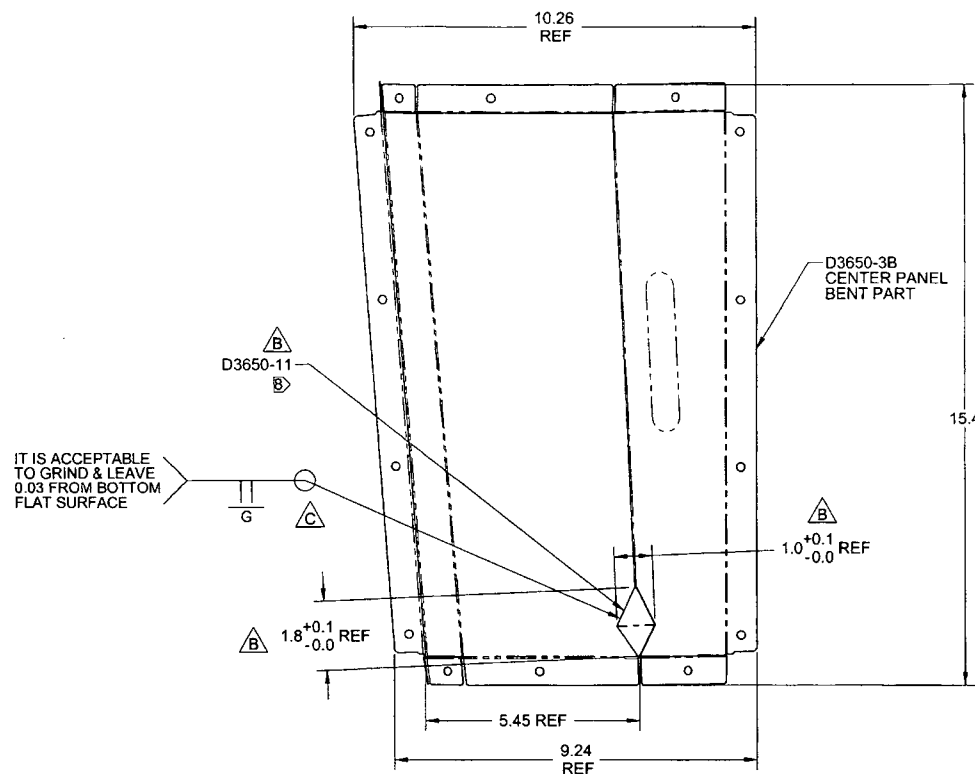
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NOTE: Date & initial all entries

00407

QTY	PART NUMBER	DESCRIPTION
-3		
X	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE



D3650-3 CENTER PANEL
(LOOKING FROM OUT SIDE SURFACE)

- NOTES:
- 1) WELD PER QSI 004
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.0 lb
 - 8) TRIM D3650-11 TO FIT AS REQUIRED

B

UNDER REVIEW

09.02.05
04.06.24

DEO ATTACHED

RELEASED
08.11.17

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3650	SHEET 4 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TOP PANEL ASSEMBLY	NTS
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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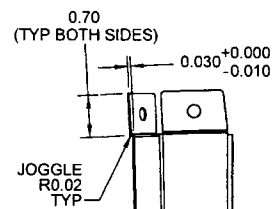
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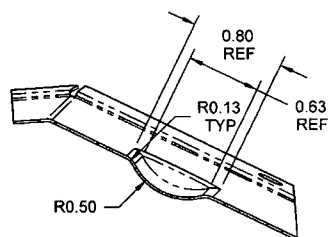
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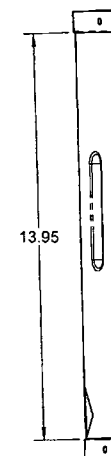
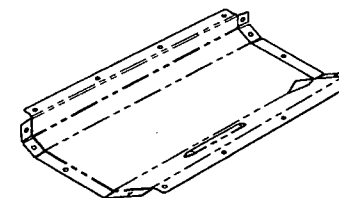
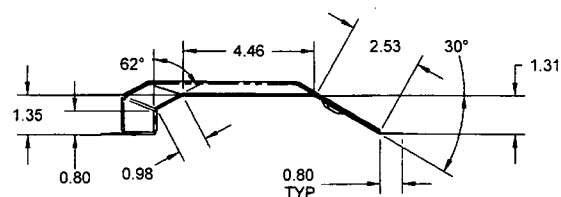
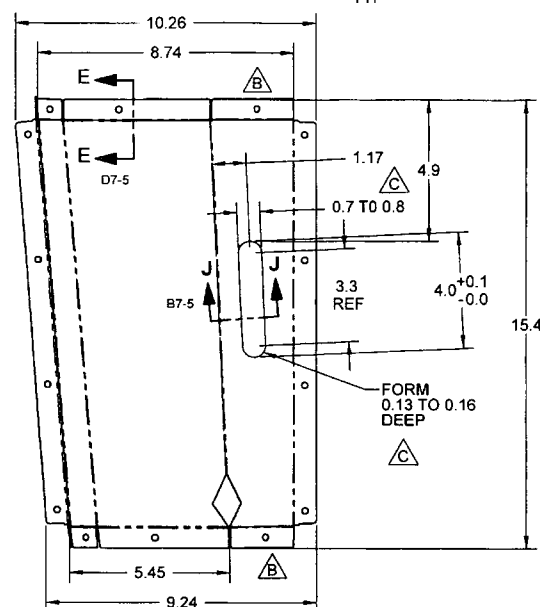
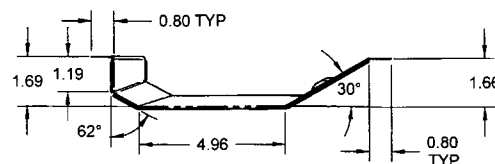
80407



SECTION E-E D5-5
SCALE 2X



SECTION J-J C5-5 \triangle
SCALE 3.5X







- NOTES:
1) FINISH: NONE
2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
3) UNITS: INCHES UNLESS OTHERWISE NOTED
4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
5) IDENTIFICATION: NONE

D3650-3B CENTER PANEL BENT PART
(MAKE FROM D3650-3F FLAT PATTERN)

UNDER REVIEW
10/9/2014

DEO ATTACHED

RELEASED
8/11/17

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3650	SHEET 5 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	
DATE	08.10.14	NTS	
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D3650-3F CENTER PANEL FLAT PATTERN

D3650-3F NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE

UNDER REVIEW
[Signature]
OK 09.26.24

RELEASED
06/11/17

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	B	DRAWING NO. D3650
MFG. APPR.	[Signature]	TITLE TOP PANEL ASSEMBLY
APPROVED	[Signature]	SCALE NTS
DE APPR.	[Signature]	
DATE	08.10.14	





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- ① DOWN 92° R 0.015
- ② DOWN 89° R 0.015
- ③ DOWN 86° R 0.015
- ④ UP 90° R 0.015
- ⑤ UP 88° R 0.015
- ⑥ UP 90° R 0.015
- ⑦ DOWN 88° R 0.015
- ⑧ DOWN 90° R 0.015
- ⑨ DOWN 94° R 0.015

RELEASED
08/11/17

~~UNDER REVIEW~~
~~CP 09.02.45~~
 OK. CP 09.02.24

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3650 TITLE TOP PANEL ASSEMBLY COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	REV. C
DRAWN	RF		SHEET 6 OF 9
CHECKED			SCALE
MFG. APPR.			NTS
APPROVED			
DE APPR.			
DATE	08.10.14		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

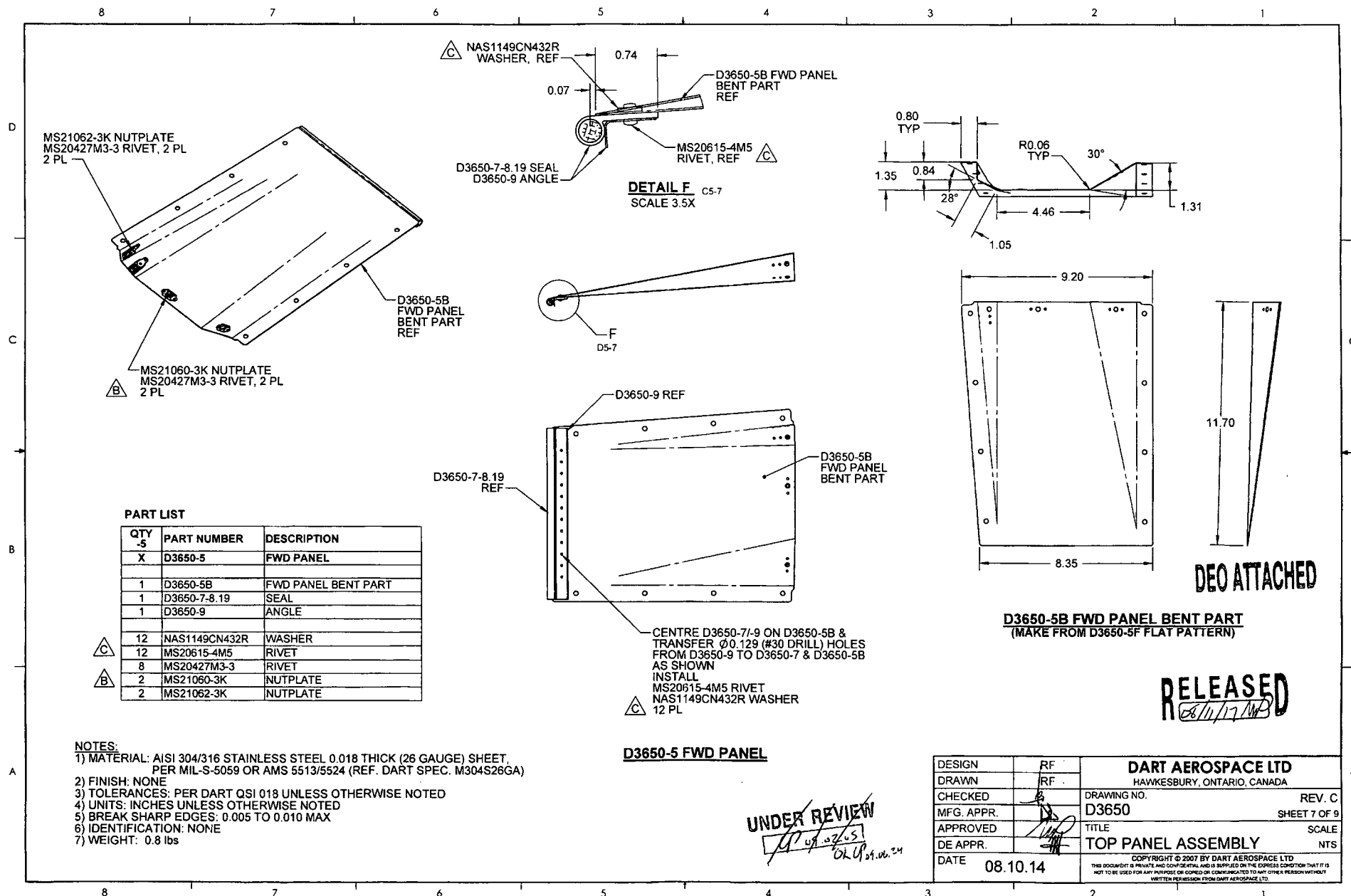
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80407



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

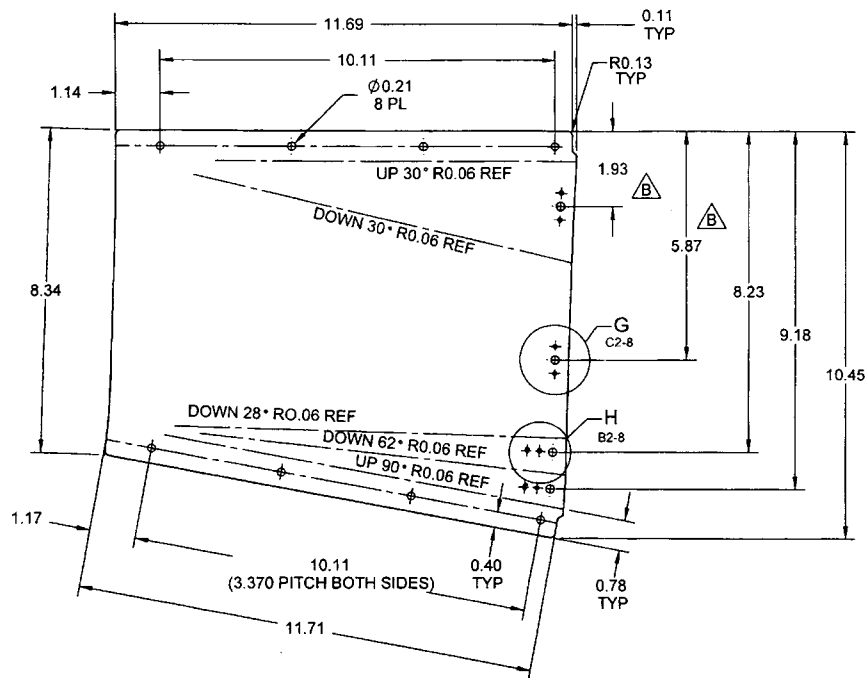
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80407

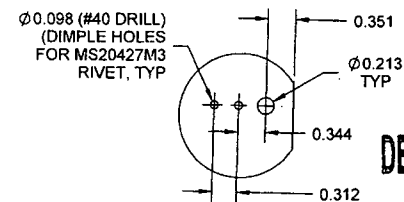
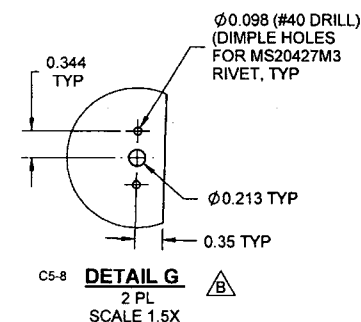
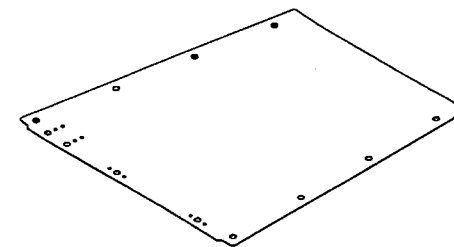


D3650-5F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb

UNDER REVIEW
[Signature]
 OK 11/17/14



DEO ATTACHED

RELEASED
 08/11/17

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. C
MFG. APPR.	[Signature]	D3650	SHEET 8 OF 9
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	TOP PANEL ASSEMBLY	NTS
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

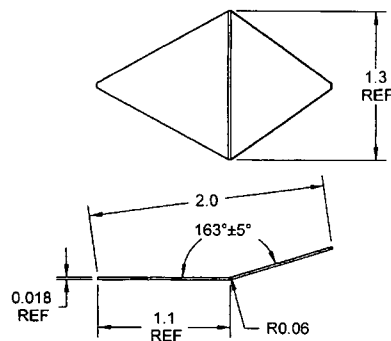
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

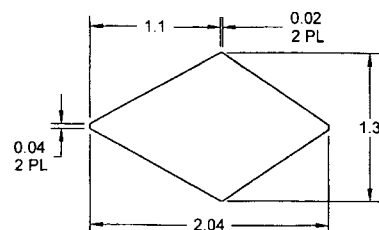
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80407



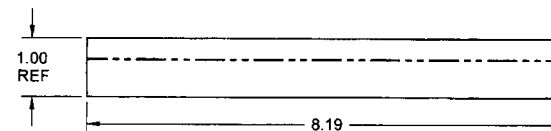
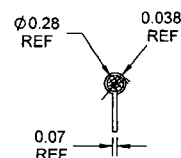
D3650-11 FILLER PLATE
(MAKE FROM D3650-11F FLAT PATTERN)



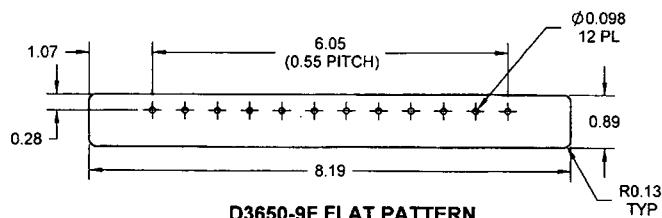
D3650-11F FLAT PATTERN



D3650-9 ANGLE
(MAKE FROM D3650-9F FLAT PATTERN)



D3650-7-8.19 SEAL



D3650-9F FLAT PATTERN

D3650-7-8.19 NOTES:

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX
WHERE X.XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50

DEO ATTACHED

RELEASED
08/10/14

D3650-9 & D3650-11 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb
D3650-11 WEIGHT: 0.007 lb

UNDER REVIEW
08/07/14
OK 08/10/14

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	B	DRAWING NO.	REV. C
MFG. APPR.	14	D3650	SHEET 9 OF 9
APPROVED	14	TITLE	SCALE
DE APPR.	14	TOP PANEL ASSEMBLY	NTS
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80407

DRAWING NO. D3650	TITLE TOP PANEL ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3650-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN CP	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 09.06.12	DATE 04.06.15	DATE 09.06.15	DATE 09/06/15		DATE 09/06/15		

TO AMEND D3650-5 FWD PANEL:

REF PAR 09-008. THE QTY(12) NAS1149CN432R WASHERS ARE REPLACED WITH QTY(1) D3893-1 DOUBLER. THE QTY(12) MS20615-4M5 RIVETS ARE REPLACED WITH QTY(12) NAS9307M-4-03 RIVETS. LOCATION OF THE DOUBLER IS SHOWN IN THE AMENDED DETAIL F (DWG SHEET 7) BELOW. THE PARTS LIST FOR D3650-5 IS AMENDED AS FOLLOWS:

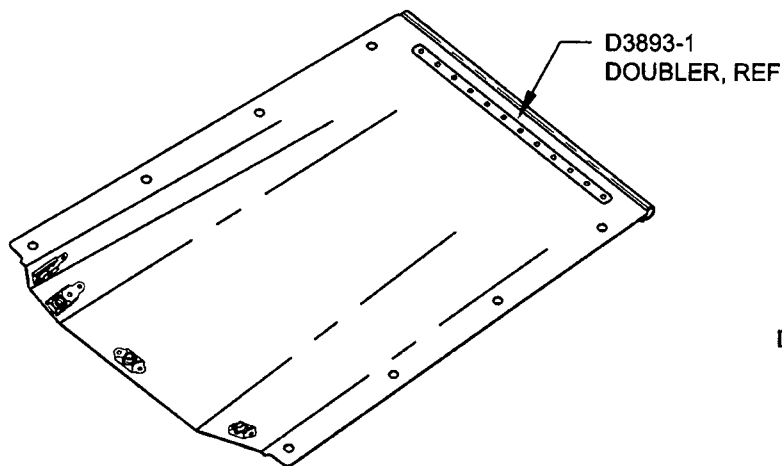
IS:

QTY -5	PART NUMBER	DESCRIPTION
1	D3893-1	DOUBLER
12	NAS9307M-4-03	RIVET (OR CR3523-4-03)

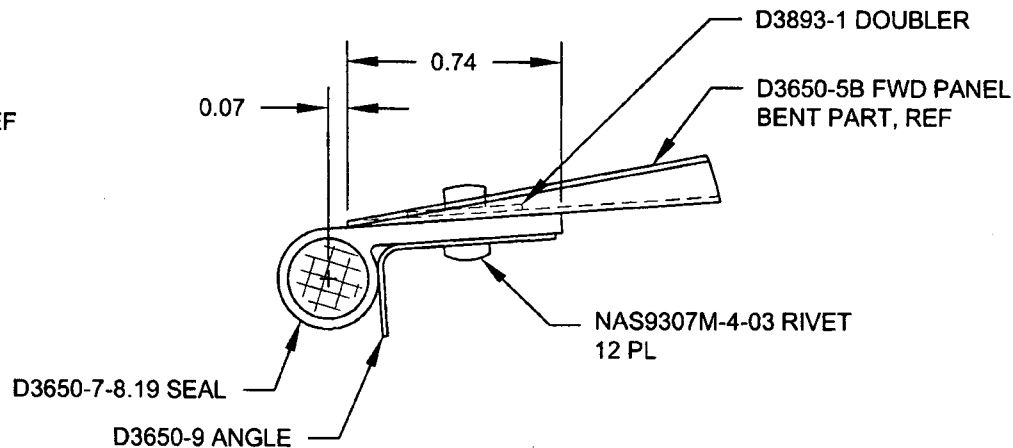
WAS:

QTY -5	PART NUMBER	DESCRIPTION
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET

RELEASED
09/06/15



D3650-5 FWD PANEL



DETAIL F C5-7
SCALE 3.5X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries